

Work Order ID 98536

Wednesday, March 13, 2013 10:33:05 AM

98536

Ship today

Page 1

Item ID: DSI 9577-011

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Cushion Installation

Stop

NS2

Start Date: 3/13/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/13/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 13-3-13 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9577

A

MS

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP DSI 9577-011 CHG001

0.00

SMB
13313

0.00

4 JGK MLT 13-3-13
(4)

12/3/13
DAS
06

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

4X

SP
13-3-13

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

27
B3B

4

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

WorkOrder ID 98536***98536***

Page 2

Wednesday, March 13, 2013 10:33:05 AM

Item ID: DSI 9577-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Cushion Installation

Stop ***NS2***

Start Date: 3/13/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/13/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI 9577-011

Location: **FG 032**PPP rev: **A**

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

(4x)**8 13/3/13****13/3/14****13-03-14**

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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FAULT CATEGORY			
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Picklist Print

Wednesday, March 13, 2013 10:33:03 AM

Page 1

Work Order ID: 98536

Parent Item: DSI 9577-011

Parent Item Name: Cushion Installation

Start Date: 3/13/2013

Required Date: 3/13/2013

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4404-1 Cushion		Manufactured	No			110	Each	12.0000	0	4	SP		SP
<div>SHD 4A</div>													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						ST143		12					
						87036		12		4x			
D4404-5 Cushion, Fwd		Manufactured	No			110	Each	7.0000	0	4	SP		SP
<div>SHD 4B</div>													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						ST143		7					
						87501		1					
						95864		6		4x			
D4404-7 Cushion, Upper Side		Manufactured	No			110	Each	7.0000	1		SP		SP
<div>SHD 4C</div>													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						ST141a		7					
						90560		7		4x			
D4404-9 Cushion, Lower Side		Manufactured	No			110	Each	4.0000	1	4	SP		SP
<div>SHD 4D</div>													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						ST143		4					
						90488		4		4x			
												SP B-3-13	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Setup <input type="checkbox"/>											
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FAULT CATEGORY											
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Reference Only SMD

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-794 REV. C OR EARLIER AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-794 REV. 2 OR EARLIER

REF. TCCA STC: SH05-4
REF. EASA STC: 10031514
REF. BRAZIL STC: 2002S09-07/-08
REF. AUSTRALIAN STC: ASR063SY

PURPOSE:

TO PROVIDE INSTRUCTIONS THAT ALLOW INSTALLATION OF D4404-1/-5/-7/-9 NEOPRENE CUSHIONS TO PREVENT THE D4055-041 AUX. FUEL TANK FROM CHAFING IN SERVICE.

CHANGE:

D350-794-011, D130-794-021, AND D350-794-041 KITS AT CHG 005 OR LATER ARE SUPPLIED TO CUSTOMERS/OPERATORS WITH D4404-1/-5/-7/-9 NEOPRENE CUSHIONS INSTALLED ON D4055-041 AUXILIARY FUEL TANK. CUSTOMERS/OPERATORS WITH D130-794-021 AND D350-794-041 KITS AT CHG 004 AND EARLIER CAN PROCURE DSI-9577-011 KIT FROM DART TO UPGRADE THEIR KITS.

PARTS LIST:

QTY	PART NUMBER	DESCRIPTION
011		
X	DSI-9577-011	CUSHION INSTALLATION
1	D4404-1	CUSHION
1	D4404-5	CUSHION, FWD
1	D4404-7	CUSHION, UPPER SIDE
1	D4404-9	CUSHION, LOWER SIDE

INSTALLATION:

INSTALL THE D4404-1/-5/-7/-9 CUSHIONS IN ACCORDANCE WITH FIGURE 1 OF THIS SERVICE INSTRUCTIONS AFTER COMPLETING STEP 5.2.8 OF THE ANNUAL/100 HOUR INSPECTION OF ICA-D350-794 BY APPLYING A THIN, UNIFORM LAYER OF CONTACT CEMENT (3M 1300/1301 SCOTCHGRIP ADHESIVE OR EQUIVALENT). TRIM TO FIT IF REQUIRED.

WEIGHT AND BALANCE:

THE FOLLOWING TABLE LISTS THE NEW WEIGHT AND BALANCE OF THE -011/-021 KITS AT CHG 005 OR LATER OR AFTER DSI-9577-011 KIT HAS BEEN INSTALLED.





INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
D350-794-011 AUXILIARY FUEL TANK (CHG 005) (AS350 MODELS)	32.7 lb 14.8 kg	-22.0 in -0.56 m	-719.4 in-lb -8.29 m-kG	126.0 in 3.20 m	4120.2 in-lb 47.4 m-kG
D130-794-021 AUXILIARY FUEL TANK (CHG 005) (EC130 MODELS)	32.7 lb 14.8 kg	-23.6 in -0.60 m	-771.7 in-lb -8.88 m-kG	126.0 in 3.20 m	4120.2 in-lb 47.4 m-kG

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 11.10.21
CERT. NO.: SH05-4
ISSUE NO.: 2

A	NEW ISSUE	MB	11.10.04
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9577	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CUSHION INSTALLATION	NTS
DATE	11.10.04	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	